

Work Order ID 56065

Page 1

February 9, 2010 1:27:25 PM

Item ID: D3535-25

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/09/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-2-09 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535

 Dwg Rev: R Prog Rev: R 2-

Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56065

Page 2

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Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-
Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

13

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

 START TIME: 3:15pm FINISH TIME: 3:15pm OVEN TEMPERATURE: 320°F
13 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56065

Page 3

February 9, 2010 1:27:25 PM

Item ID: D3535-25

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Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/09/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

bf 10-03-3

(13)

QC

Memo

0.00

Quality Control

170



Identify as per dwg & Stock Location: FP-18

0.00

M 10/03/03

(X13)

Packaging

Memo

0.00

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/03 M

MF
10-3-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

February 9, 2010 1:27:29 PM

Work Order ID: 56065



Parent Item: D3535-25



Parent Item Name: Wearshoe

Start Date: 2/09/10

Required Date: 2/15/10

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	229.1294	6.4421	7.		BR 10-2-12

304/316 .040 Sheet

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	229.1294053	
110076	0.40253684	
112567	38.0765789	
112885	36.9578	
113062	145.1723	113062
113077	8.52018947	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56005
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	<u>10-2-12</u>	Date:	<u>10-2-12</u>	Date:	N/A

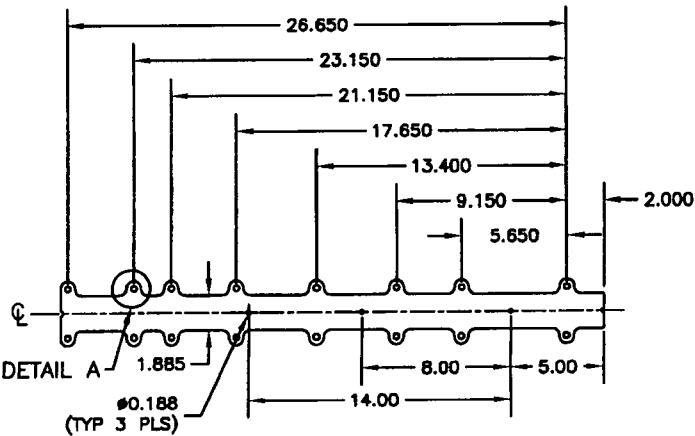
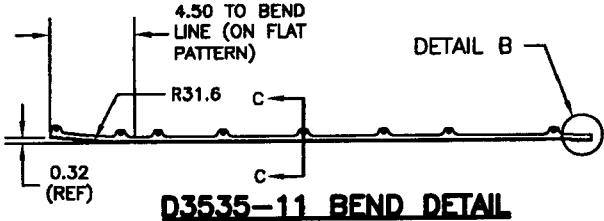
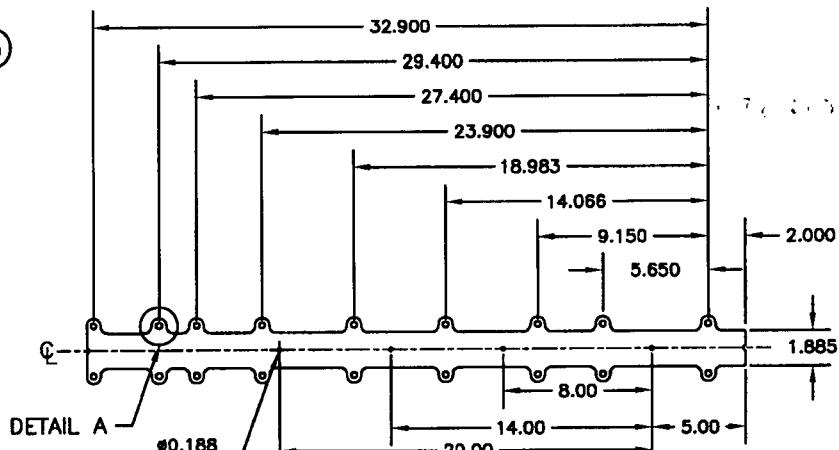
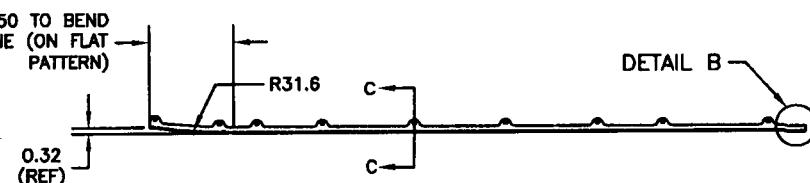
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

DART

DESIGN CB DRAWN BY **M** DART AEROSPACE USA, INC.
 PORT HADLOCK, WA
 REV. B

CHECKED M	APPROVED M	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	SHEET 1 OF 7
A 06.10.25	NEW ISSUE	SCALE 1:10
B 07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

RELEASER
07.04.24

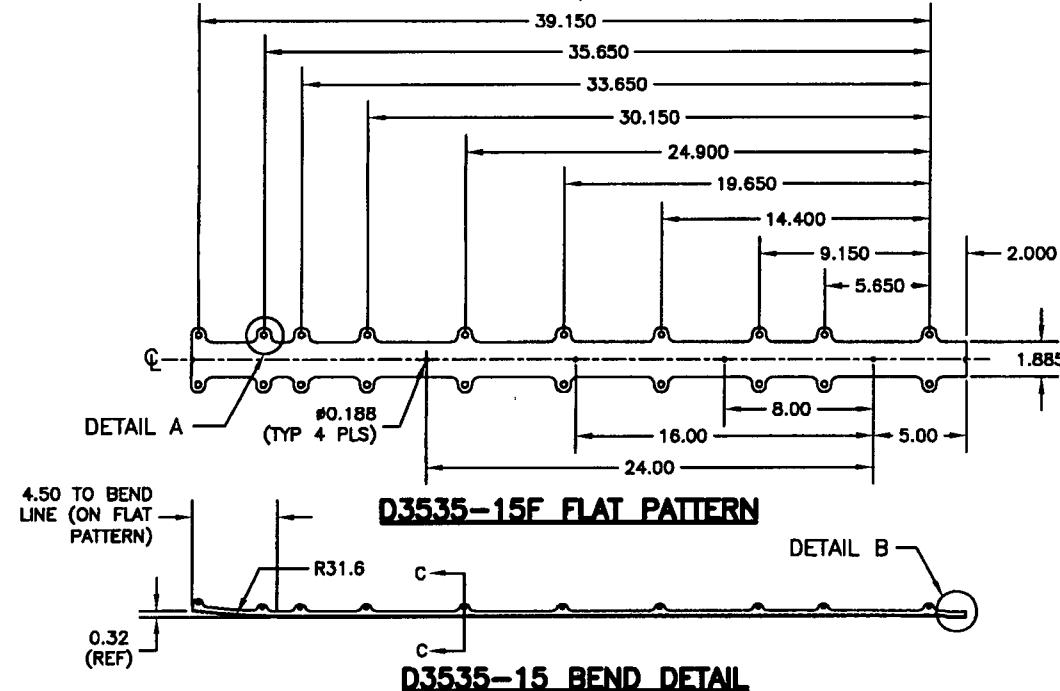
**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

NOTES

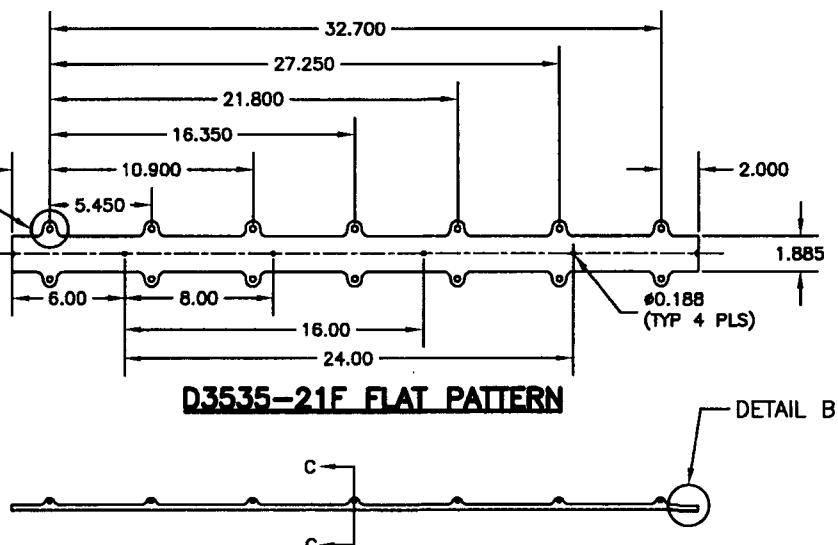
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

RELEASED

67.04.24 *H***NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
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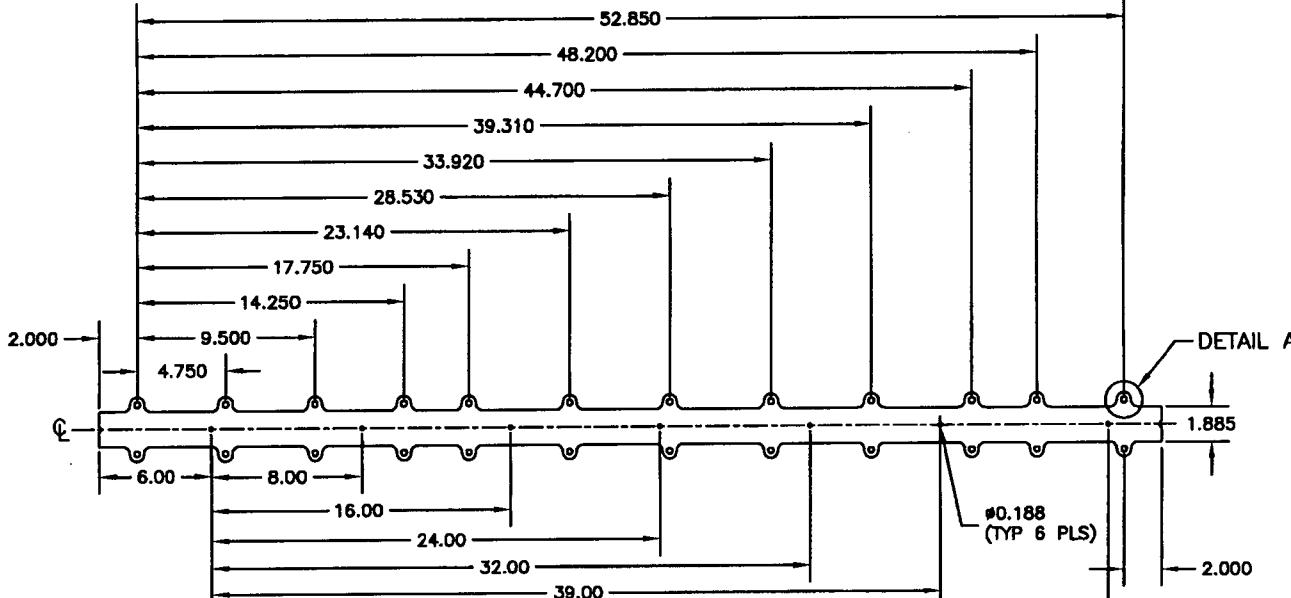
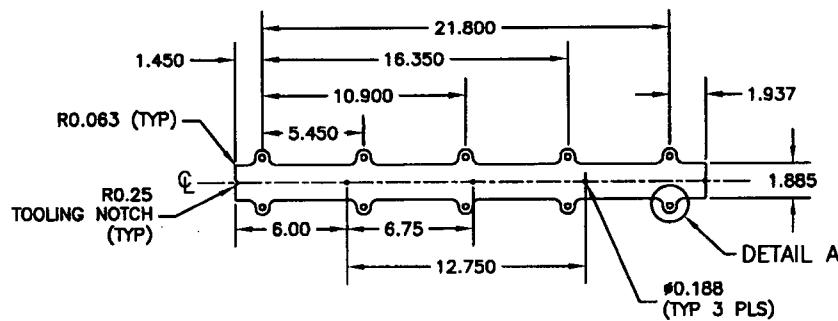


DESIGN CB	DRAWN BY <i>PJ</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>H</i>	APPROVED <i>MH</i>	DRAWING NO. D3535
DATE 07.04.17		SCALE 1:10

6/16/2015

DART

DESIGN CB	DRAWN BY M	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED M	APPROVED M	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 3 OF 7 SCALE 1:10

**D3535-23 BEND DETAIL**

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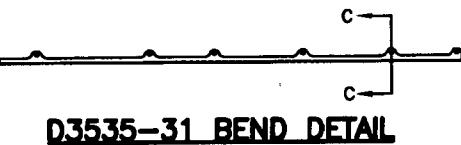
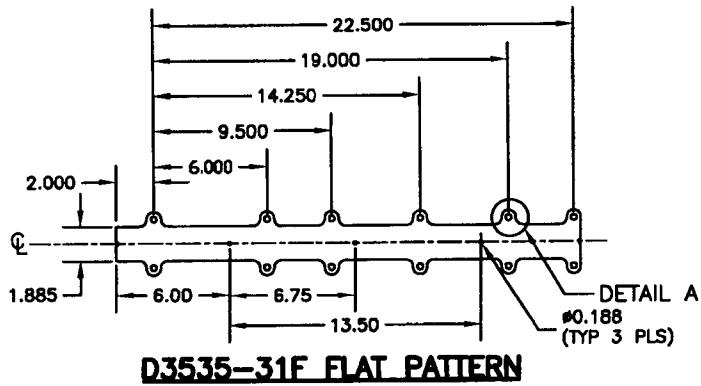
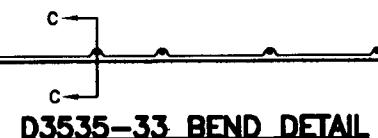
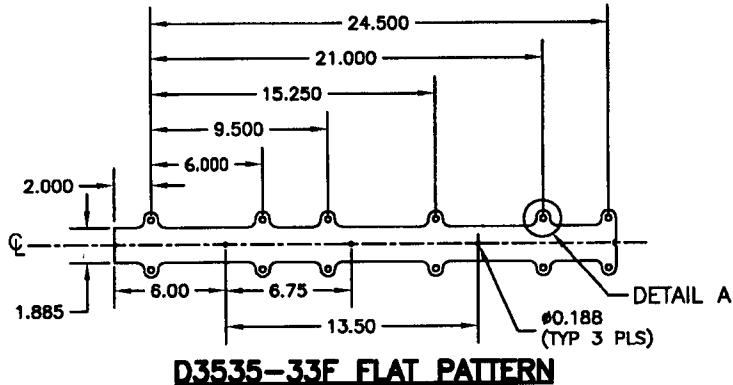
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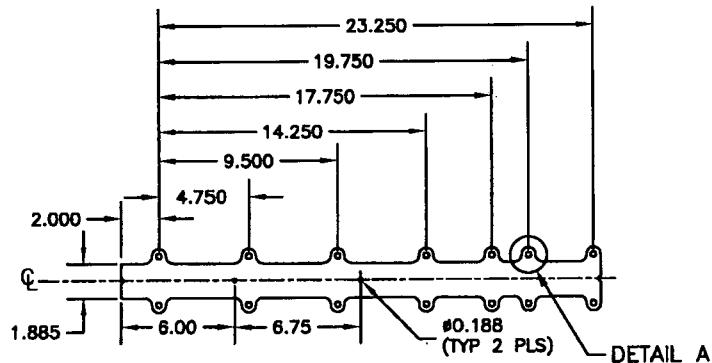
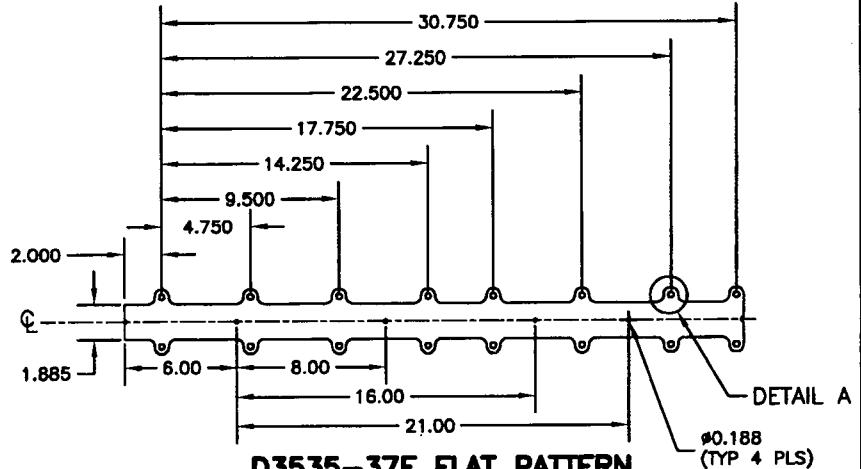
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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DART

DESIGN C.B	DRAWN BY <i>MH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>MH</i>	APPROVED <i>MH</i>	DRAWING NO. D3535
DATE 07.04.17		TITLE WEARSHOE
		REV. B SHEET 4 OF 7 SCALE 1:10

RELEASED
07.04.17



DARTRELEASED
07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

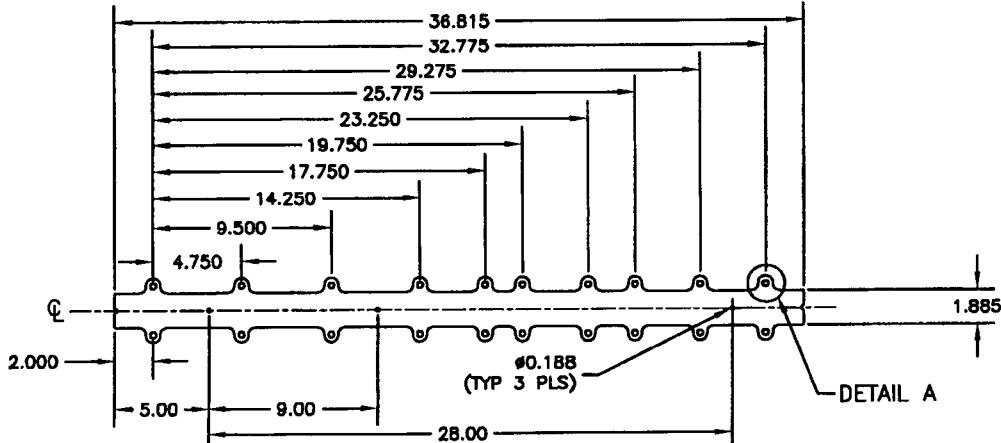
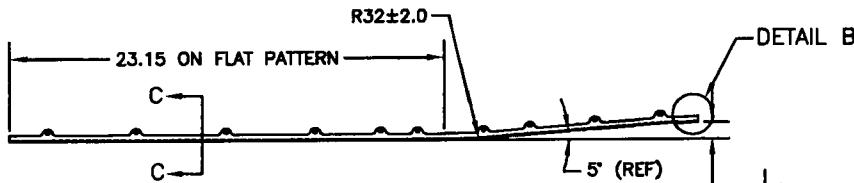
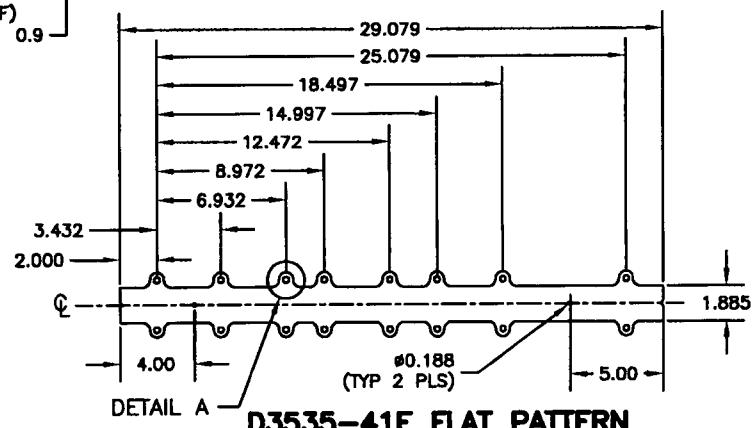
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CHECKED M	APPROVED M	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 5 OF 7 SCALE 1:10

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
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PAINT MARKER
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DART

DESIGN C8	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED /	APPROVED /	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7 SCALE 1:10

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304520GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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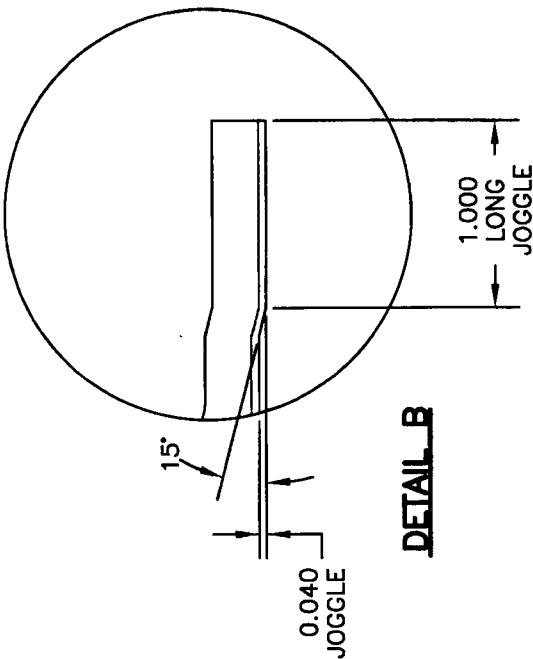
DART

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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE	SCALE 1:1

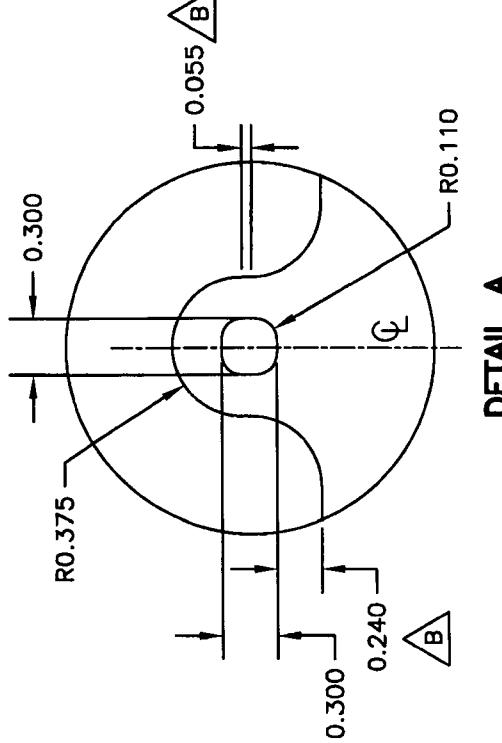
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RELEASED

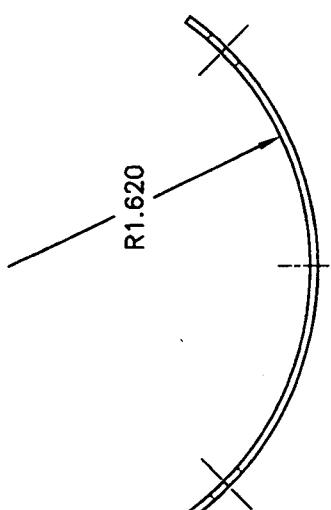
07.04.24 *[initials]*



DETAIL B



DETAIL A



SECTION C-C

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